





**Work Order ID 52307**

Tuesday, September 22, 2009 2:33:14 PM



Page 3

Item ID: D2666-1

Accept



Setup Start



Revision ID: D

Stop



Item Name: Saddle, LH Fwd Aft In 206

Start Date: 9/23/2009 Start Qty: 8.00



Cust Item ID:

Required Date: 10/9/2009 Req'd Qty: 8.00



Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start



QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
160  QC Quality Control	QC3- Inspect Part Finish  Memo	0.00  0.00	MD 09/10/19			X8			
170  Packaging Packaging	Identify as per dwg & Stock Location: <u>426</u>  Memo	0.00  0.00				9/10/19	80	SP	
180  QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00  0.00				09/10/19	AF		MF 09-10-19

# Picklist Print

Tuesday, September 22, 2009 2:33:14 PM

Page 1

Work Order ID: 52307



Parent Item: D2666-1RevD



Parent Item Name: Saddle, LH Fwd Aft In 206

Start Date: 9/23/2009

Required Date: 10/9/2009

Comments:

Start Qty: 8.00

Required Qty: 8.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D6101-001RevB		Manufactured	No			100	Each	0.0000	8.0000			
Saddle Billet												

B 46409 X 8

52

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	52307
<b>Description:</b> 206 Saddle, Inboard, Left side	<b>Part Number:</b>	D2666-1
<b>Inspection Dwg:</b> D2666 Rev. D		Page 1 of 1

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	1	2	3	4		
A	0.100	0.140		.130	.123	.123	.127		
B	0.100	0.140		.126	.126	.125	.125		
C	2.470	2.510		2.490	2.490	2.490	2.493		
D	0.100	0.180		.125	.125	.125	.126		
E	0.210	0.230		.220	.220	.219	.219		
F	1.313	1.343		1.324	1.324	1.324	1.321		
G	0.240	0.260		.251	.250	.251	.249		
H	0.615	0.685		.665	.665	.665	.660		
I	1.125	1.145		1.133	1.135	1.134	1.135		
J	0.990	1.010		1.000	1.000	1.000	1.000		
K	0.235	0.240		.236	.236	.236	.237		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.110	.111	.110	.110		
N	1.565	1.585		1.573	1.575	1.574	1.574		
O	5.990	6.010		6.000	6.002	6.001	5.999		
P	1.245	1.255		1.250	1.250	1.250	1.250		
Q	2.495	2.505		2.500	2.500	2.500	2.504		
R	0.490	0.510		.500	.497	.494	.498		
S	0.313	0.318		.314	.314	.314	.314		
T	2.495	2.505		2.500	2.500	2.500	2.500		
U	1.357	1.367		1.362	1.362	1.362	1.362		
V	0.315	0.322		.319	.319	.319	.320		
W	0.540	0.560		.549	.550	.550	.550		
X	1.674	1.684		1.679	1.679	1.679	1.679		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198		.188	.188	.188	.188		
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by:	SK
Date:	09/10/14

Audited by:	amf
Date:	09/10/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	

<b>DART AEROSPACE LTD</b>	<b>Work Order:</b>	<b>52307</b>
<b>Description: 206 Saddle, Inboard, Left side</b>	<b>Part Number:</b>	<b>D2666-1</b>
<b>Inspection Dwg: D2666 Rev. D</b>		<b>Page 1 of 1</b>

Inspect dimensions highlighted on inspection sheet drawing D2666 Rev. D and record below:

				Recorded Actual Dimensions				By	Date
Dim	Min	Max	Go/No Go Gauge	# 5	# 6	# 7	# 8		
A	0.100	0.140		.125	.125	.125	.127		
B	0.100	0.140		.125	.124	.123	.124		
C	2.470	2.510		2.492	2.490	2.490	2.49		
D	0.100	0.180		.137	.139	.140	.136		
E	0.210	0.230		.220	.219	.217	.220		
F	1.313	1.343		1.321	1.326	1.325	1.326		
G	0.240	0.260		.250	.250	.250	.250		
H	0.615	0.685		.659	.663	.667	.658		
I	1.125	1.145		1.136	1.138	1.136	1.136		
J	0.990	1.010		.999	1.000	1.000	.999		
K	0.235	0.240		.237	.236	.235	.239		
L	0.510	0.515		.510	.510	.510	.510		
M	0.100	0.120		.110	.110	.110	.110		
N	1.565	1.585		1.575	1.575	1.575	1.575		
O	5.990	6.010		6.001	6.000	6.001	6.000		
P	1.245	1.255		1.247	1.248	1.248	1.248		
Q	2.495	2.505		2.500	2.503	2.500	2.500		
R	0.490	0.510		.501	.501	.498	.500		
S	0.313	0.318		.315	.316	.316	.316		
T	2.495	2.505		2.500	2.500	2.494	2.500		
U	1.357	1.367		1.360	1.360	1.360	1.360		
V	0.315	0.322		.320	.317	.320	.320		
W	0.540	0.560		.549	.543	.546	.545		
X	1.674	1.684		1.678	1.679	1.680	1.681		
Y	0.257	0.262		.258	.258	.258	.258		
Z	0.178	0.198							
AA									
AB									
AC									
AD									
AE									
AF									
Accept/Reject									

Measured by: *[Signature]*  
Date: 02/10/15

Audited by: *[Signature]*  
Date: 09/10/16

Rev	Date	Change	Revised by	Approved
A		New Issue	RF	
B	99.04.19	Incorporated DSI 9095, DSI 9102 & DSI 9122 Rev. A	RF	
C	99.11.10	Added Dim. R-T	RF	
D	02.12.12	Reformat; Added Dim. U-W & DT8683, DT8686 & DT8695 A/B	KJ/RF	
E	06.06.30	Dimension revised per drawing revision C	KJ/JLM	
F	06.09.19	Reference to DT8888 added to Dim N	KJ/EC	
G	07.03.21	Revised per drawing revision D	KJ/JLM	<i>[Signature]</i>

SHOP COPY





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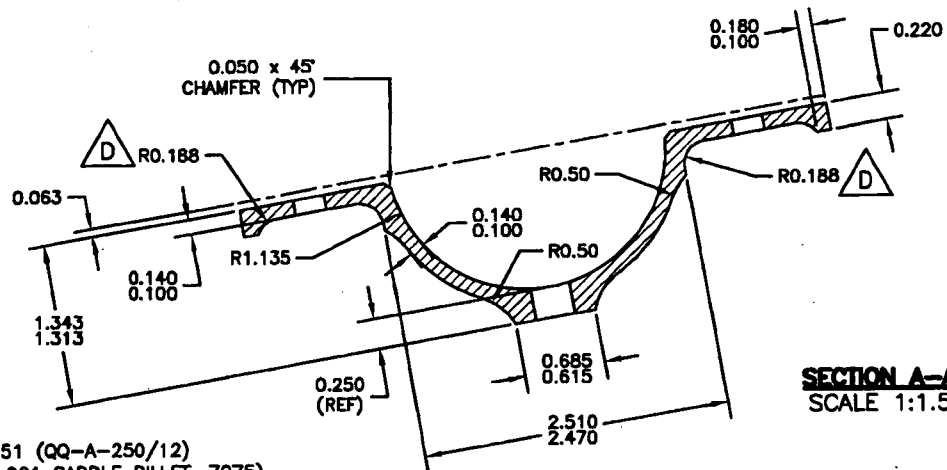
WITHOUT NOTICE  
WORK ORDER

NO. 52307

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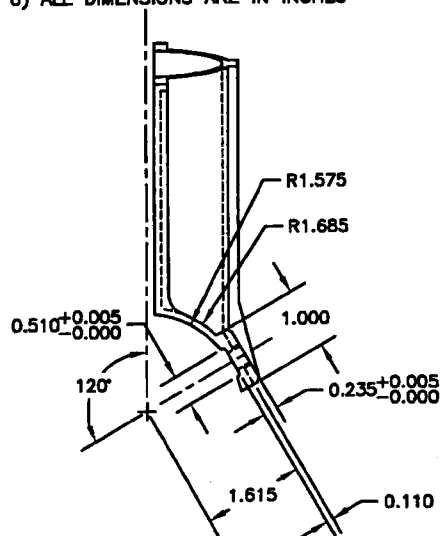
07-02-12

DESIGN 		DRAWN BY 		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2666	REV. D SHEET 1 OF 1
DATE 06.11.08			TITLE SADDLE FWD INSIDE HIGH		SCALE 1:3
A	97.03.25		NEW ISSUE		
B	97.07.11		ANGLE AND NOTES ADDED		
C	06.05.26		INCORPORATE DEO 9122, 9102, 9095		
D	06.11.08		R0.188 WAS R0.30; Ø0.316 WAS Ø0.313		

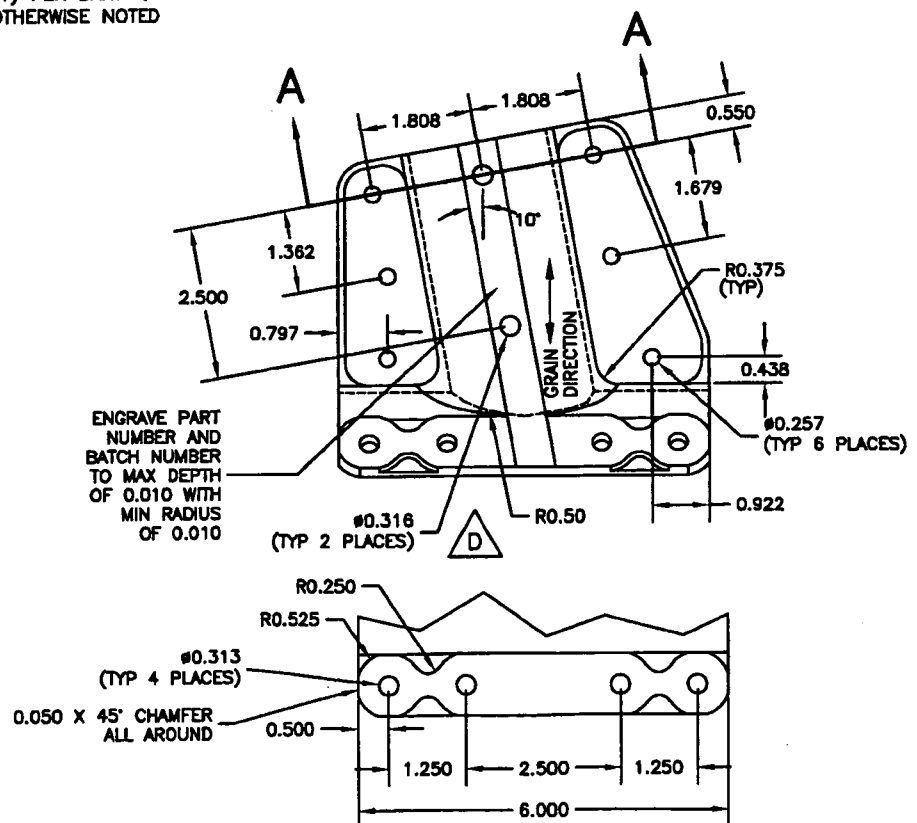


## NOTES:

- 1) MATERIAL: ALUMINUM 7075-T7351 (QQ-A-250/12)  
(MAKE FROM D6101-001 SADDLE BILLET, 7075)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
POWDER COAT GLOSS WHITE (4.3.5.1) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) BREAK ALL SHARP EDGES 0.010 TO 0.020
- 5) D2666-1 SHOWN (D2666-2 IS OPPOSITE)
- 6) ALL DIMENSIONS ARE IN INCHES



D2666-1 SADDLE FWD INSIDE HIGH



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